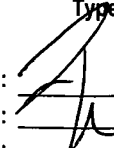
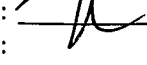


Date: Thursday, 26/02/2009 7:09:17 AM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b>	: CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b>	: D205-596-101 CUT TO 105
<b>Job Number</b>	: 46069		
<b>Estimate Number</b>	: 10804		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D205596105
<b>This Issue</b>	: 26/02/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: R09-020
<b>First Issue</b>	: / /	<b>Project Number</b>	:
<b>Previous Run</b>	: 00015	<b>Drawing Revision</b>	:
<b>Written By</b>	: 	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: 	<b>Due Date</b>	: 04/03/2009
<b>Comment</b>	:	<b>Qty:</b>	1 Um: Each

## Additional Product

Job Number:



DC HJ for JLD 09.03.03

CH6002

Seq. #: Machine Or Operation: Description:

1.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

05.02.26 (1)



1x D205-596-101 original B34945 returned to be cut too 32.5" high, per dwg D205-596-105

2.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1



\*\*\* Ensure that the entire surface of the x-tube is protected, so the customers paint does not get damaged.\*\*

Mark off cut lines to trim as a -105 @ 32.5".

9-2-27

3.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES



9-2-27

4.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1



-Cut the tube as per dwg D205-596-105.

-Debur, and scribe the end of the cuff with the new batch & part number.

- Touch up the affected area's with alodine,, and yellow primer as per QSI 005.

9-2-27

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.03.03 (1)



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D205-596-101 CUT TO 105

Job Number: 46069

Part Number: D205596105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

New labels decals and paperwork are required with the new batch #.

Re-package the tube per PPP

Prepare tube for shipment back to the customer.

New ARC required with the new batch # & part #.

Rev 2

59

(14)

9/3/3

7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

\*\*\*\*INSPECT THE BATCH # AND PAPERWORK.\*\*\*\*

CHG002

509/03/03

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/03

Job Completion



11 09-03-03

<b>DART</b>		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
P N	D205-596-101	CHG	CHG002
DESC	Crosstube Fwd Extended	STC	SH03-6
LOT	B34945	STC	SR01742NY
MOD	205/212	STC	
MADE IN CANADA			

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

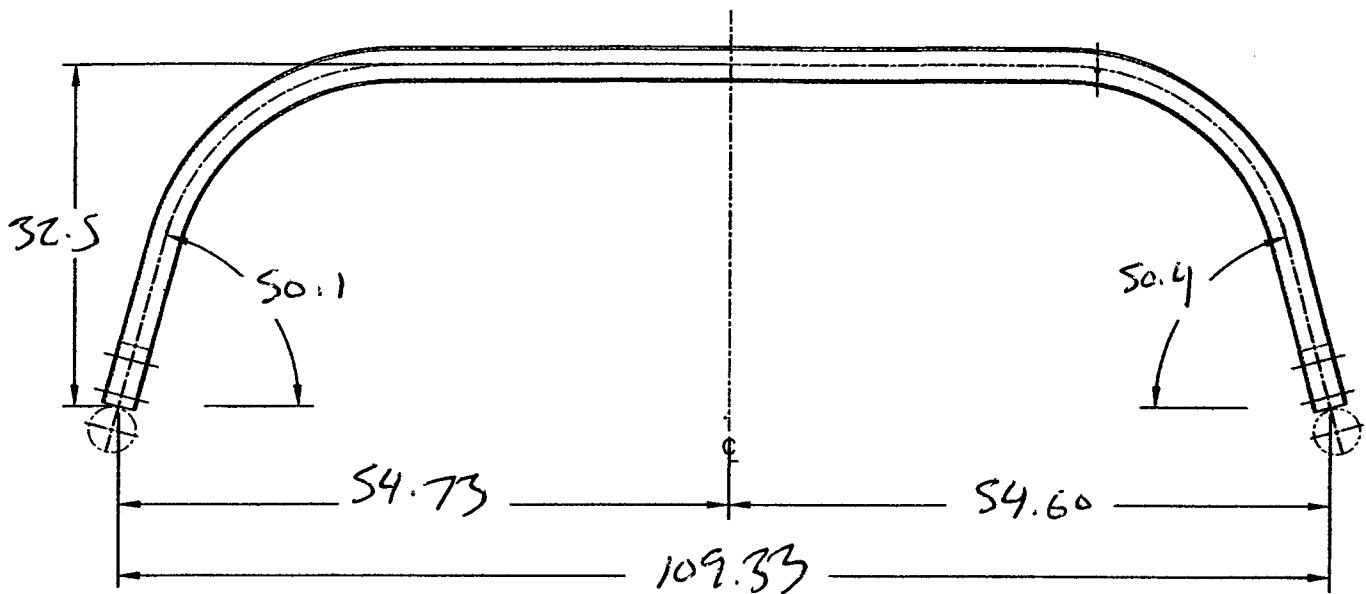
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	46069
<b>Description:</b> Crosstube High-High Fwd	<b>Part Number:</b>	D205-596-105
<b>Inspection Dwg:</b> D205-596-105 <b>Rev:</b> B		<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	32.4	32.6
1/2 Span	54.6	54.8
Angle	49	52
Total Span	109.2	109.6



Comments

QC15 Inspection	07.02.27
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	

**PARTS LIST:**

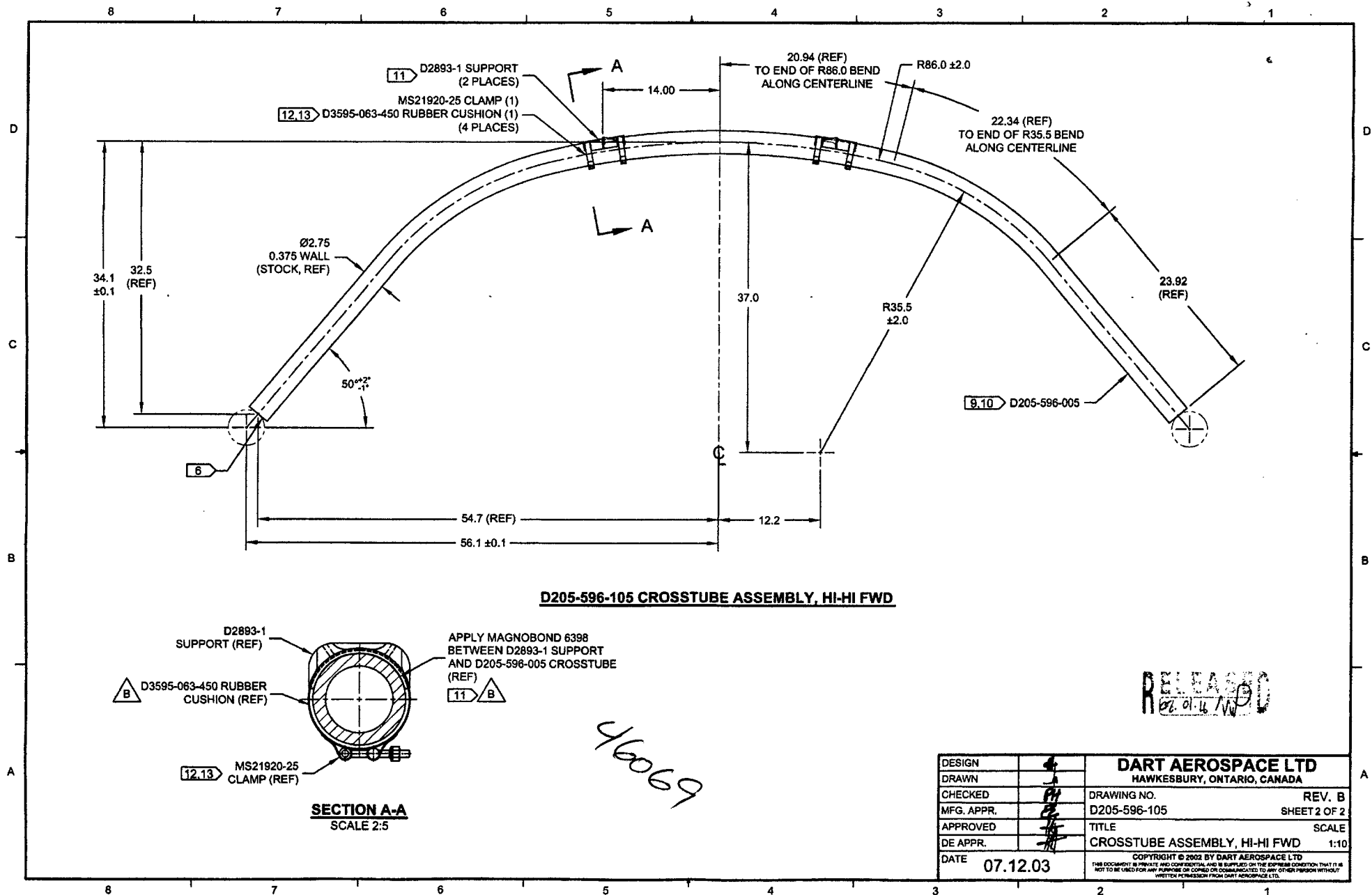
Qty	Part Number	Description
X	D205-596-105	CROSSTUBE ASSEMBLY, HI-HI FWD
1	D6005-180	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D6005-180  
FINISHED LENGTH = 134.40 ± 0.02
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH  
VIBRATING STYLUS
- 7) WEIGHT: 40 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT  
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION  
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1  
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE  
CROSSTUBE SUPPORT.  
**NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-25 CLAMPS WITH LONGER (MS21920-26) OR  
SHORTER (MS21920-24) CLAMPS TO ACCOMODATE VARYING DIAMETERS. ENSURE THERE IS A  
MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.**
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

RELEASED  
06-01-14

B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-851 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-450 CUSHION; MS21920-25 WAS MS21920-24	MB	07.12.03
A	NEW ISSUE	DS	02.11.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D205-596-105	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE ASSEMBLY, HI-HI FWD	NTS
DATE	07.12.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**Jason Murdoch**

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**From:** dshepherd@dartaero.com  
**Sent:** February 26, 2009 12:34 PM  
**To:** jmurdoch@dartaero.com  
**Cc:** Peggy  
**Subject:** Fw: RMA528 R09-020

Jason,

Just got cc'd on this by Peggy. You are correct. You need to turn those tubes into -105 and -107. The 31" is just a rough estimate of the height when installed on the aircraft. I recommend getting Chris to inspect the cut locationss before you make the cuts.

David

Sent from my BlackBerry device on the Rogers Wireless Network

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**From:** peggy@darths.com  
**Date:** Thu, 26 Feb 2009 15:17:40 +0000  
**To:** Jason Murdoch<jmurdoch@dartaero.com>; David Shepherd<dshepherd@dartaero.com>  
**Subject:** Re: RMA528 R09-020

Hi Jason -im the wrong person to ask. all I know is the customer has returned 39" as they realized they should have purchased 31" I'm travelling today but back in the office tomorrow

Sent from my BlackBerry device on the Rogers Wireless Network

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**From:** "Jason Murdoch"  
**Date:** Thu, 26 Feb 2009 10:08:10 -0500  
**To:** 'Peggy McDonald'<peggy@darths.com>  
**Subject:** RMA528 R09-020

Good morning Peggy,  
I'm creating the custom w/o's for the D205-596 gear to cut as per the customer request to 31", written on the return form.  
I just would like to make sure, as to what is needed, because none of our drawings for the D205-596 models are cut TO 31". The only thing I can see is that the D205-596-105 fwd & -107 aft gears are "considered" 31".

Here are the dims of what the original tubes are:  
D205-596-101 fwd are 38.3" high  
D205-596-103 aft are 37.3" high

Here is what we can cut them to in accordance with our drawings, turning them into:  
D205-596-105 fwd at 32.5" high  
D205-596-107 aft at 29.8" high

Is this correct?

26/02/2009



Jason Murdoch  
**Qc. Coordinator**  
jmurdoch@dartaero.com

***"We provide solutions"***

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26/02/2009